

Work Order ID 155899

Wednesday, January 18, 2017 7:35:40 AM

155899

Page 1

Item ID: D5076-043

Revision ID:

Item Name: Fwd Inboard Bracket Assembly

Start Date: 1/13/2017 Start Qty: 4.00

Required Date: 1/19/2017 Req'd Qty: 4.00

Reference:

Accept

DAS
21
9-89***N900040100***Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

4
4 2Approvals: Process Plan: DAS 21 9-89 Date: JAN 20 2017

Tooling:

Date:

QC: DAS 21 9-89 Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D5076	A
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110

0.00

110

Packaging

Memo

Pck Kit

0.00

Packaging

120

0.00

120

Small Fab

Memo

1-Assemble as per dwg, do not install grommets and rubber seal.

0.32

Small Fab

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

DAS
38
9-89
FEB 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Work Order ID 155899

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Page 2

Item ID: D5076-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Inboard Bracket Assembly
Start Date: 1/13/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/19/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
140									
Powdercoat	Memo <u>M136370</u>	0.03							
Powder Coating	*** MASK NUT PLATE HOLES PER DWG ***								
	START TIME: <u>2:50</u>								
	OVEN TEMPERATURE: <u>320°</u>								
	FINISH TIME: <u>3:20</u>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.01							
Quality Control									
160		0.00							
160									
Small Fab	Memo	0.35							
Small Fab	Install rubber seals and grommets.								
	3M 1300 batch: <u>M134871</u>								

2. 0 17-02-7 34 9-88

2 FF FEB 07 2017

2 FF FEB 08 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
									
							Completed By		
							Lead hand / Supervisor Approval Verification		
					QC / QA Coordinator Approval				

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

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Item ID: D5076-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Inboard Bracket Assembly
Start Date: 1/13/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/19/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01			DAS 30 9-89	②			FEB 08 2017
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST</i> Memo	0.00 0.01			DAS 30 9-89	②			FEB 08 2017
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07						17/2/19 <i>TH</i>	

DAS
21
9-89

FEB 08 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Picklist Print

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Page 1

Work Order ID: 155899

155899

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 1/13/2017

Required Date: 1/19/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.04.01 PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-9 *D4434-9* Bracket		Manufactured	No			110	Each	0.0000	1	4	DAS 30 9.89	FEB 02 2017	
D4441-1 *D4441-1* Rubber Seal		Manufactured	No				f	451.7720		1.732		FF	FEB 08 2017
Location Loc Qty Loc Code													
ST422 201.772													
151347 201.772													
ST625 250													
151347 250													
D4441-1 *D4441-1* Rubber Seal		Manufactured	No				f	451.7720		2.132		FF	FEB 08 2017
Location Loc Qty Loc Code													
ST422 201.772													
151347 201.772													
ST625 250													
151347 250													
D4441-1 *D4441-1* Rubber Seal		Manufactured	No				f	451.7720		3.12		FF	FEB 08 2017
Location Loc Qty Loc Code													
ST422 201.772													
151347 201.772													
ST625 250													
151347 250													

4

B155205

②

1.732 0.866

2.132 1.066

3.12 1.56

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 2

Work Order ID: 155899

155899

Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 1/13/2017

Required Date: 1/19/2017

Start Qty: 4.00

Required Qty: 4.00

D4441-1 Manufactured No

451.7720

2.2

D4441-1

FF FEB 08 2017

Rubber Seal

Location

Loc Qty

Loc Code

ST422

201.772

151347

201.772

2.2 1.1

ST625

250

151347

250

D5076-1 Manufactured No

110

Each

4.0000

1

4

D5076-1

DAS
30
9-89

FEB 02 2017

Bracket

Location

Loc Qty

Loc Code

ST614

4

154008

4

2 DAS
30
9-89

D5076-3 Manufactured No

110

Each

4.0000

1

4

D5076-3

FEB 02 2017

Bracket

Location

Loc Qty

Loc Code

ST614

4

153082

4

B 155244

②

D4435-041 Manufactured No

110

Each

7.0000

1

4

D4435-041

DAS
30
9-89

FEB 02 2017

Bracket Assembly

Location

Loc Qty

Loc Code

ST098

7

151718

3

153094

2

154300

2

2

Tuesday, January 17, 2017 1:57:37 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____					
☐ Misidentified	☐ Past Due						

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Parent Item: D5076-043

D5076-043

Parent Item Name: Fwd Inboard Bracket Assembly

Start Date: 1/13/2017

Required Date: 1/19/2017

Start Qty: 4.00

Required Qty: 4.00

D4441-1 Manufactured No

451.7720

0.568

D4441-1

FF FEB 08 2017

Rubber Seal

Location

Loc Qty

Loc Code

ST422

201.772

151347

201.772

0.568 0.284

ST625

250

151347

250

D4441-1 Manufactured No

451.7720

0.832

D4441-1

FF FEB 08 2017

Rubber Seal

Location

Loc Qty

Loc Code

ST422

201.772

151347

201.772

0.832 0.416

ST625

250

151347

250

D4440-1 Manufactured No

160 Each

29.0000

1

4

D4440-1

FF FEB 08 2017

Grommet

Location

Loc Qty

Loc Code

GA

29

152234

10

153108

19

2

AN525-832R6 Purchased No

110 Each

110.0000

3

12

AN525-832R6

FF FEB 08 2017

Screw

Location

Loc Qty

Loc Code

GA

16

136207
m135390

16

ST328

94

m136044

94

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Start Date: 1/13/2017

Required Date: 1/19/2017

Start Qty: 4.00

Required Qty: 4.00

MS20426AD3-3 Purchased No

110 Each 5,099.000 14 56

MS20426AD3-3
RIVET

FF

FEB 02 2017

Location	Loc Qty	Loc Code
fg108	440	
M134946	200	
M135354	120	
M135894	120	
GA	1830	
M135274	1830	
ST312	2829	
M135274	2829	

28

MS20470AD4-3 Purchased No

110 Each 2,502.000 15 60

MS20470AD4-3
Rivet, Universal Head

FF

FEB 02 2017

Location	Loc Qty	Loc Code
GA	1147	
2193	141	
m135536	1006	
ST	1355	
m135536	1355	

30

MS21075L08 Purchased No

110 Each 177.0000 7 28

MS21075L08
ANCHOR NUT

DAS 30 38

FEB 02 2017

Location	Loc Qty	Loc Code
ST298	177	
M135774	102	
M136182	75	

14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														